

Revised P.W.

# Work Order ID 48525

June 26, 2009 4:02:42 PM



Item ID: D076-612-015

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cargo Mirror Assembly

Start Date: 15/07/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI9304

Rev A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D076-612-015 CHG002

After CC 09/07/01

5 09/07/01

110

0.00



Packaging

Pick Kit

Memo

Packaging

0.00

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

5 09/07/01 (42)

# Work Order ID 48525

June 26, 2009 4:02:42 PM



Page 2

Item ID: D076-612-015

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cargo Mirror Assembly

Start Date: 15/07/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D076-612-015 Location: \_\_\_\_\_ PPP Rev: \_\_\_\_\_

Recd 08/07/09

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

08/07/09

MF 09-07-07

June 26, 2009 4:02:41 PM

Page 1

**Parent Item:** D076-612-015RevA

**Parent Item Name:** Cargo Mirror Assembly

**Comments:**

**Start Date:** 15/07/2009

**Required Date:** 03/08/2009

**Start Qty: 2.00**

**Required Qty: 2.00**

[illegible]

# Picklist Print

June 26, 2009 4:02:41 PM

Page 2

Work Order ID: 48525

Parent Item: D076-612-015RevA

Parent Item Name: Cargo Mirror Assembly










Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2263-3RevC 	S	Manufactured	No			120	Each	197.0000	4.0000	B15445		C
✓ Castings D2264RevA 	S	Manufactured	No			120	Each	18.0000	6.0000	B48469		C
✓ Cushion D2271RevA 	S	Manufactured	No			120	Each	19.0000	6.0000	B16178		C
✓ "L" Bracket Assembly D2274RevF 	S	Manufactured	No			120	Each	506.0000	4.0000	B47796		C
✓ Radius Block D2856-100-250RevA 	S	Manufactured	No		transmtd	120	Each	0.0000	4.0000	B42076		C
ABRASION STRIP D3439-101RevA 	S	Manufactured	No			120	Each	3.0000	2.0000	B47152		C
Mirror Assembly 8" MS21042L3 	S	Purchased	No			120	Each	1,873.000	12.0000	M111274		C
Nut MS21042L4 	S	Purchased	No			120	Each	9,086.000	6.0000	M110507		C
Nut MS27039-1-14 	S	Purchased	No			120	Each	75.0000	6.0000	M15924	9/6/30	C (2)
Screw												

June 26, 2009 4:02:41 PM

Shop Packet Print

Page 2

# Picklist Print

June 26, 2009 4:02:41 PM

Page 3

Work Order ID: 48525

Parent Item: D076-612-015RevA

Parent Item Name: Cargo Mirror Assembly


Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1738B-4-2		Purchased S	No			120	Each	107.0000	18.0000			
												
Blind Rivet												

B705443 7X 9/6/30 20 (2)  
M112082 11X

June 26, 2009 4:02:41 PM

Shop Packet Print

Page 3

Date: Friday, 12/06/2009 9:53:27 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: CARGO MIRRO 8"
<b>Job Number</b>	: 48525		
<b>Estimate Number</b>	: 12528		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D076612015
<b>This Issue</b>	: 12/06/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: DSI9304 REVC
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 48468	<b>Drawing Revision</b>	: A
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	: N/A
<b>Written By</b>	:	<b>Due Date</b>	: 19/06/2009
<b>Checked &amp; Approved By</b>	: <u>Julie Dawson</u>	<b>Qty:</b>	2
<b>Comment</b>	: Est Rev:A 05.05.12 New issue KJ/JLM	<b>Um:</b>	Each

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

✓ DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D076-612-015 CHG002

2.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0

✓ D2012117

Clevis

**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Clevis

4.0

✓ D2261

Mirror Arm - Long S76

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mirror Arm - Long S76

5.0

✓ D2262

Mirror Arm - Short S76

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mirror Arm - Short S76

6.0

✓ D22631

Clamp

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 12/06/2009 9:53:27 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CARGO MIRRO 8"

Job Number: 48525

Part Number: D076612015

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

7.0

D22633

Castings



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

8.0

D2264

Cushion



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cushion

9.0

D2271

"L" Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

"L" Bracket Assembly

10.0

D2274

Radius Block



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Radius Block

11.0

D2856100250

ABRASION STRIP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

ABRASION STRIP

12.0

D3439101

Mirror Assembly 8"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

MIRROR

13.0

AN311A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

14.0

AN45A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 12/06/2009 9:53:27 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CARGO MIRRO 8"

Job Number: 48525

Part Number: D076612015

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

15.0

✓ AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt

16.0

✓ AN960JD10

Washer



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Washer

17.0

✓ AN960JD416

Washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)  
Washer

18.0

✓ MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Nut

19.0

✓ MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Nut

20.0

✓ MS27039114

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Screw

21.0

✓ NAS1738B42

Blind Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Blind Rivet

22.0

✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 12/06/2009 9:53:28 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CARGO MIRRO 8"

Job Number: 48525

Part Number: D076612015

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D076-612-015

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSI 9304	REV. C SHEET 1 OF 2
DATE 05.06.13		TITLE MIRROR SUBSTITUTION	SCALE NTS
A	05.05.27	NEW ISSUE	
B	05.06.03	ADD OPTIONAL ANTI-SLIP HARDWARE	
C	05.06.13	NOW PERMANENT KIT CHANGE	

**DART SERVICE INSTRUCTION**  
TO AMEND INSTALLATION INSTRUCTIONS IIN-D076-612 REV. A  
REF. CANADIAN STC: SH94-38 ISSUE 2  
REF. FAA STC: SR00298NY

For the D076-612-015 CHG 002 Cargo Mirror kit, the D2011-103 Mirror referenced in IIN-D076-612 rev.A has been replaced with the D3439-101 Mirror Assembly. The attaching hardware for this mirror has been changed to reduce the chance of slippage in flight. The mirror should be installed per the figure on page 2 of this document. The parts list for the D076-612-015 Cargo Mirror kit is given below.

Qty -015	Part Number	Description
X	D076-612-015	CARGO MIRROR, 8"
1	D3439-101	Mirror Assembly(8")
1	*D3015-3	Locknut
1	*5/16WC	Washer
3	D2012-117	Clevis
1	D2261	Arm Assembly
1	D2262	Arm Assembly
2	D2263-1	Clamp
2	D2263-3	Clamp
3	D2264	Cushion
3	D2271	Bracket
2	D2274	Radius Block
2	D2856-100-250	Abrasion Strips
3	AN3-11A	Bolt
2	AN4-5A	Bolt
1	AN4-10A	Bolt
9	AN960JD10	Washer
10	AN960JD416	Washer
6	MS21042L3	Nut (or MS21042-3)
3	MS21042L4	Nut (or MS21042-4)
3	MS27039-1-14	Screw
9	NAS1738B-4-2	Blind Rivet

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 48525

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

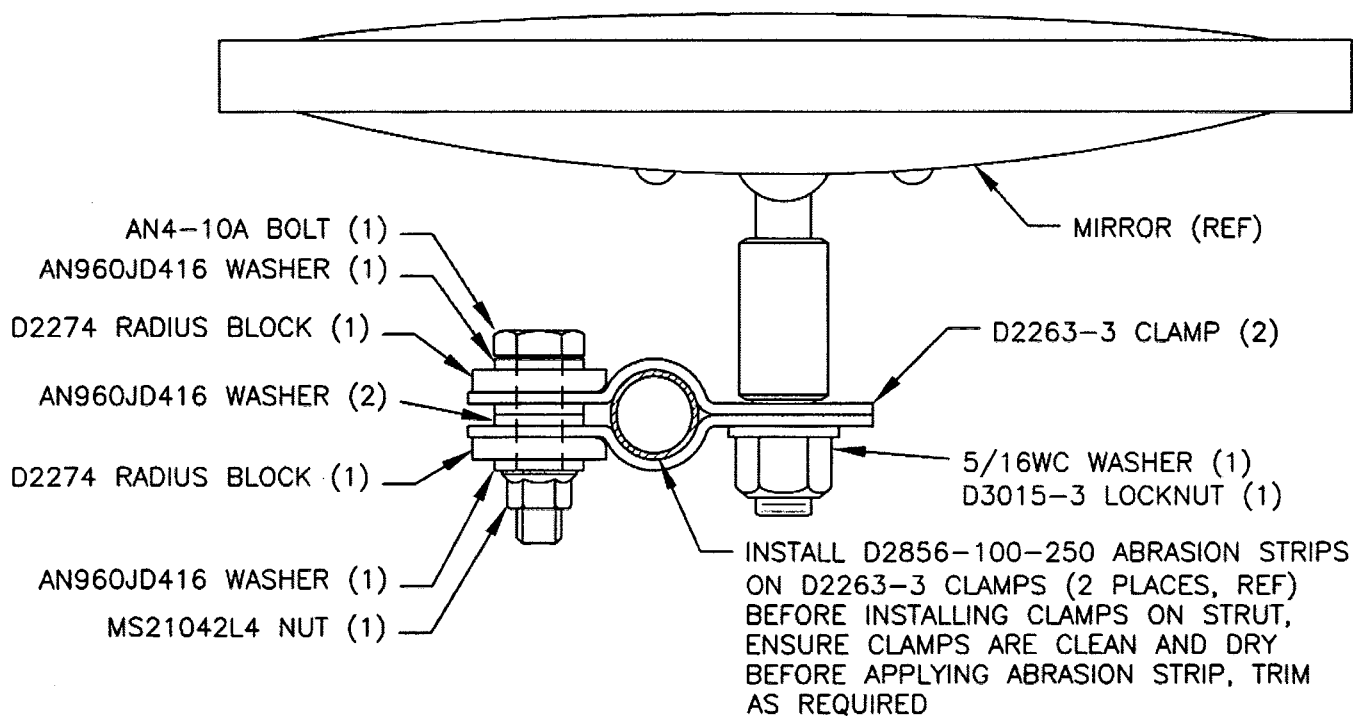
DATE: 05.06.13  
CERT. NO.: SH94-38  
ISSUE NO.: 2

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9304	REV. C SHEET 2 OF 2
DATE 05.06.13		TITLE MIRROR SUBSTITUTION	SCALE NTS



**VIEW OF FIGURE 5 (DETAIL 'C')**  
**of IIN-D076-612 Rev. A**

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WORK ORDER  
NO. *48525*

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO #01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE #02)
DATE:	05.06.13
CERT. NO.:	SH94-38
ISSUE NO.:	2

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